

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019421**Date Inspected:** 18-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

This QA Inspector observed ZPMC personnel performing fit-up of top bearing plates with bearing stiffener plates (at PP119-1500 and PP119+1500). See attached photo for further information.

OBG Seg 13CW:

This QA Inspector observed that the tack welds of Deck Panel Diaphragm to Deck Panel Floor Beam (at PP123 and 123.5) got cracked while pre-heating was in progress. This was informed to ZPMC QC, identified as Zhang Ling and ABF QA, Kasi Wang. These tack welds were removed, MT was done by ZPMC and refit-up of DP Diaphragm to Floor Beam was done. See attached photos for further information.

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OBG Seg 14W:

Repair welding of weld joint no: SEG3020Y-022 [Floor Beam (FB) 3327A to Longitudinal Diaphragm (LD) 3051A, Complete Joint Penetration (CJP) weld at Panel Point (PP) 127]. The welder is identified as 051348 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 20152 Rev-0.

Repair welding of weld joint no: SEG3020BB-073 [Bottom Plate (BP) 3090A to Sub Assembly (SA) Plate SA3451A, CJP weld in between PP125 to PP126]. The welder is identified as 067949 and was observed welding in the 2G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-2G(2F)-ESAB-REPAIR-FCM. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR 2752 Rev-0.

The SMAW process on weld joint no: SEG3020F-066 (FB3336A to FB3338A, CJP weld at PP128). The welder is identified as 067520 and was observed welding in the 1G position. ZPMC CWI was identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-P-2211-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

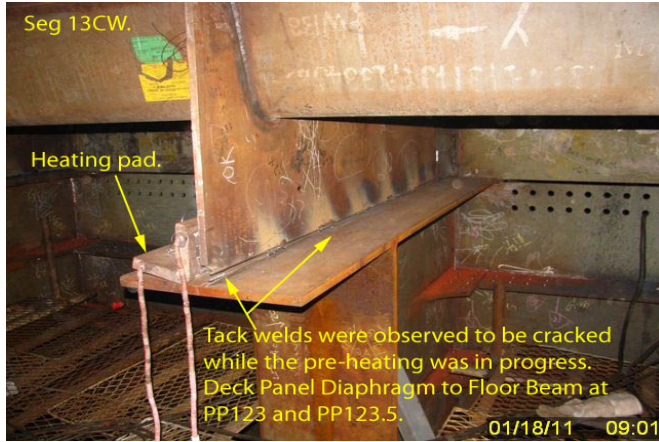


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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer